

# Work Order ID 50267

July 14, 2009 10:57:04 AM

Page 1

Item ID: D2850-1

Accept

Revision ID: A

Item Name: End Bracket

Start Date: 7/15/09 Start Qty: 10.00

Required Date: 7/15/09 Req'd Qty: 10.00

Reference:

*09.07.16*

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2850

Rev A

100

0.00



BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut blanks: 3.8"

*inf 09/07/24*

10

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine per Folio D2850-1 □ Debur and Tumble

*DTA 09/07/28*

10

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

*DTA 09/07/28*

10

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 50267

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Item ID: D2850-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: End Bracket

Start Date: 7/15/09

Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

09.07.29 (10)

Quality Control

140

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

04/7/30 (12)

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/07/30

30-07-09 BH 10

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

July 14, 2009 10:57:03 AM

Work Order ID: 50267

Parent Item: D2850-1RevA

Parent Item Name: End Bracket

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.500X01.50 0		Purchased	No			100	f	41.5700	3.3768			



6061-T6 Bar 2.50 x 1.50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

41.57

100947

5.57

16742

36

100947

3.3768

ml 07/12/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> High Float Step End Bracket		<b>Part Number:</b>	<b>D2850-1</b>
<b>Inspection Dwg:</b> D2850 <b>Rev:</b> A		<b>Page 1 of 1</b>	

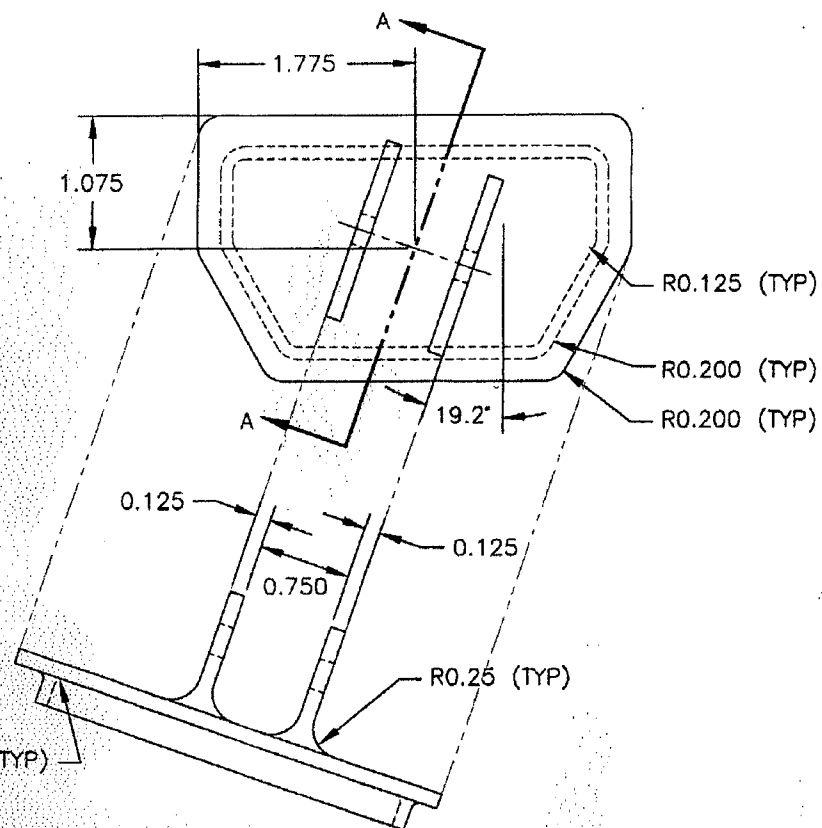
### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                 
 ☐ **Prototype**

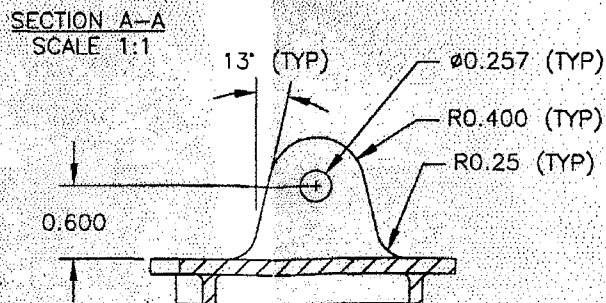
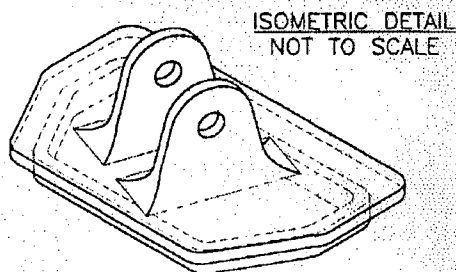
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.720	+0.000/-0.030	1.719	✓			
0.178	+/-0.010	0.177	✓			
0.10	+/-0.030	0.097	✓			(TYP)
30.0°	+/-0.5°	30.0°	✓			
2.15	+/-0.030	2.153	✓			(TYP)
0.375	+/-0.010	0.371	✓			
0.125	+/-0.010	0.122	✓			
1.00	+/-0.030	1.003	✓			(REF)
R0.125	+/-0.010	0.125	✓			
19.2°	+/-0.5°	19.2°	✓			
0.125	+/-0.010	0.135	✓			
0.750	+/-0.010	0.751	✓			
0.600	+/-0.010	0.601	✓			
0.189	±0.010	0.179	✓			
3.55	±0.03	3.552	✓			
3.170	+0.000/-0.03	3.168	✓			
R0.25	±0.03	0.250	✓			
0.257	+0.006/-0.001	0.260	✓			

<b>Measured by:</b> <i>DA</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/07/28	<b>Date:</b> 09-07-29	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.05	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
FINISH: NONE  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



50267

RELEASED  
95/125 86

A	98.11.10	NEW ISSUE, REPLACES D2357 REV. A AND D2358 REV. B	
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART</b>	DART AEROSPACE LTD WILLOWBURRY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>#</i>	DRAWING NO. D2850	REV. A SHEET 1 OF 1
DATE 98.11.10		TITLE HIGH FLOAT STEP END BRACKET	SCALE